Insp.

August-09-12 10:12:04 AM Item ID: D350-591-311 Accept \*N900040100\* Setup Start **Revision ID:** Item Name: Heli-Access-Step. Long LH \*10\* **Start Date:** 09/08/2012 **Start Qty: 10.00 Cust Item ID: Required Date:** 23/08/2012 Req'd Qty: 10.00 **Customer:** Reference: Run Process Plan: \_\_MLJ Date: 12/08/59 Tooling: Approvals: Date: SPC (Y/N): Date: Sequence ID/ Operation Tool ID Tool # Reject Reject Set Up/ Plan Accept **Work Center ID** Qty **Description Oty** Number Stamp **Run Hours** Code Draw Nbr **Revision Nbr** D3272 Rev B 100 0.00 DOCUMENT CONTROL MUJ 12/08/22 \*100\* DC 0.00 Memo 9\_83 Document Control Photocopy bluefile and type labels as per PPP D350-591-311 CHG001 110 0.00 Large Fab \*110\* Large Fab 0.00 Memo Large Fab 1-Bevel end for welding FWD ONLY

D3272

A/RAluminum Rod / 3-Grind End Plate flush

2-Weld Support using Jig DT8719, weld Fwd End Plate as per QSI 004 & Dwg

										•			DQA:	Date	a:
NCR:	Yes	/ No				<b>WORK ORDER</b>	NON-C	ON	IFORN	ANCE / UP	DATE		•		•
													QA Closed:	Date	9:
Work Ord	er.				3	DISPOSITI	ON	I			AGAINST	DE	PARTMENT	PROCESS	
Part I	No.						ework Scrap e-as-is pdate		Therm	Skid-tube  Machining  noforming  Large Fab	Crosstube Small Fab Finishing Composite			Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root					Descri	ption of work order	update	i,	nitial	Ac	tion		Sign &		
Cause		Date	Step	Qty	(	or Non-conformance		Chi	ief Eng	Desc	ription		Date	Verification	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved						. *	**					-			
							; F <i>F</i>	AUL	T ČATE	GORY					
Landi						General	- 1					г	1	Г	
٤	Bending Centre Not Concentric to O/S Cracks Crushed/Crimped. Cuffs				o/s	BOM/Route Broken/Damaged Burrs Contamination				on Incomplete ions Incomplete/	'Unclear		Ovalized Over/Under Part Incorred Part Lost/Mi Part Moved	ssing ·	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled
.		Heat Trea	t			Countersink			Mislabe	led		1	Positioned V	Vrong	

Misread

Out of Calibration
Out of Sequence

Outside Dimensions

Offset

Power Loss/Surge

Other

Ripples in Bend

Turning Sequence

Wave/Twist in Tube

Inspection Strip in Tube

Torque Waves in Extrusion

Cut Too Short

Drill Holes

Drawing

Finish Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

### Work Order ID 88884

August-09-12 10:12:04 AM

Item ID:

D350-591-311

**Revision ID:** 

Item Name: Heli-Access-Step, Long LH

QC:

**Start Date:** 09/08/2012 **Required Date: 23/08/2012** 

**Start Qty: 10.00** Rea'd Otv: 10.00

\*N900040100\*

Setup Start

**Cust Item ID:** 

**Customer:** 

Approvals:

Reference:

**Process Plan:** 

Date: Date:

Tooling:

SPC (Y/N):

Set Up/

Date:

Date:

Run

Stop

Sequence ID/ Work Center ID

120

\*120\*

QC Quality Control Operation Description

Memo

Memo

QC9- Inspect visual per QSI004- Fusion Welds

Run Hours 0.00

0.00

Tool ID

Tool # Plan Code

Accept Qty

Reject Qty

Reject

Number Stamp

DAS 10 89

130

\*130\* QC

Quality Control

QC5- Inspect part completeness to step on W/O

140

Chemical Conversion Coat per QS1005 4.1

0.00

\*140\* HandFinish

Hand Finishing

Memo

0.00

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					<b>,</b>	i.				*4.		
						7				DQA:	Date:	•
NCR:	Yes / No				<b>WORK ORDER NON-</b>	CON	<b>IFORI</b>	MANCE / U	PDATE			خ
	<u></u>	-				كمم				QA Closed:	Date:	
					DISPOSITION				AGAINST D	EPARTMENT	/PROCESS	
Work Orde	er:		<del></del>		1	- 1	-,		. –	٦	_	l rasinopsing
Dort N	do.				Rework	- 1,	1	Skid-tube	Crosstube	- Dro	Water Jet d. Eng. Coor.	Engineering Quality
Part N	NO				Scrap Use-as-is	-   Ĭ		Machining noforming	Small Fab Finishing	_	re/Packaging	Other
NCR N	do.				Work Order Update	- I		Large Fab	Composite	- Rec/3101	Supplier	
HONT	···				Work Order opdate	_	,	raige lan	Composite		3upplie:	
Root				Descri	ption of work order update	l ir	nitial	1	Action	Sign &	T	
Cause	Date	Step	Qty		or Non-conformance		ef Eng		scription	Date	Verification	QC Inspector
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Equip/Tooling												
Operator												
Material												
Setup				1,0	53 P - 1							
Other				\$ 1 m.5	1.)\$°						1	
Process												
Supplier												
Training	_											
Unapproved		<u> </u>								<u> </u>		
					<del></del>	AULT	CATE	GORY				
Landin	g Gear				General		Grain		Г	Ovalized	<u></u>	Pressure/Forced
	Bending Centre No	ot Concor	atric to	\s\ \-	Bend BOM/Route	$\vdash$	Ji aiii Hardwa	ro	-	Over/Under	tolerance	Temperature/Cure
	Cracks	or concer	itric to	<sup>5/3</sup>  -	Broken/Damaged	$\vdash$		on Incomplete		Part Incorre	<del> </del>	Weld
ŀ	Crushed/0	Crimned			Burrs	$\overline{}$		ions Incomplete	e/Unclear`	Part Lost/M	<u> </u>	Wrong Stock Pulled
-	Cuffs	cimpea,		<u> </u>	Contamination	-	Mainte		- Concical	Part Moved		
	Heat Trea	t			Countersink		Mislabe		F	Positioned V		
F	Inspection		Tube	<b> </b>	Cut Too Short	$\vdash$	Misread		F	Power Loss/		Other
F	Ripples in	•			Drill Holes	-	Offset		_		· L	
	Torque W		xtrusio	,  -	Drawing	$\vdash$		Calibration				
ľ	Turning Se				Finish	П	Out of S	equence				
	Waye/Twi	ict in Tuh	_		Folio	$\square$	Jutcido	Dimonsions				

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Accept

0.00

0.00

Work Order ID 88884 August-09-12 10:12:04 AM Item ID: D350-591-311 **Revision ID:** Item Name: **Start Date:** 09/08/2012 **Required Date: 23/08/2012** Reference: Process Plan: Approvals:

Heli-Access-Step, Long LH Start Oty: 10.00 Req'd Qty: 10.00

Date: Tooling: QC: SPC (Y/N): Date: Sequence ID/ Operation Set Up/ Work Center ID Description **Run Hours** 150 QC3- Inspect Part Finish 0.00 \*150\* QC 0.00

Memo

Quality Control 180

Large Fab \*180\* Large Fab Memo Large Fab

1-Assemble Leg Assembly as per Dwg D3272. 2-Leave one rivet out until welding is complete. 3-Bevel Aft end for welding 4-Inspect for foreign object as per QSI 024 5-Weld Aft End Plate as per QSI 004 & Dwg D3272 A/RAluminum Rod 120 85 6-Grind End Plate flush

7-Install last rivet as per Dwg.

Setup Start

Cust Item ID: **Customer:** 

> Date: Date:

Run Start Stop

Reject Tool ID Tool# Plan Accept Reject Insp. Qty Qty Number Stamp Code

												DQA:	Date	<b>3</b> :	
NCR:	Yes	/ No					WORK ORDER NON-C	100	NFOR	MANCE / UPD	ATE	-		_	,
												QA Closed:	Date	e:	
Vork Ord	er:						DISPOSITION		5		AGAINST DE	PARTMENT/	PROCESS		1
Part NCR							Rework Scrap Use-as-is Work Order Update		Therr	Skid-tube  Machining  noforming  Large Fab	Crosstube Small Fab Finishing Composite	4	Water Jet J. Eng. Coor. e/Packaging Supplier		Engineering Quality Other
Root					Des	cris	otion of work order update		Initial	Acti	on	Sign &		Т	
Cause		Date	Step	Qty			or Non-conformance	ı	nief Eng	1'.		Date	Verification		QC Inspector
oc/Data uip/Tooling perator aterial									N.	10 mm - 3					
etup ther ocess applier aining napproved															
							F.	٩UL	T CATE	GORY					
Landi							General		•			٠	Г	ij	O
	-	Bending Centre No Cracks	t Concen	ntric to (	o/s		Bend BOM/Route Broken/Damaged		Grain Hardwa Inspect	re on Incomplete		Ovalized Over/Under Part Incorred	<b> </b>		Pressure/Forced Temperature/Cure Weld
,		Crushed/C	rimped.				Burrs		1	ions Incomplete/U	nclear	Part Lost/Mi	ssing		Wrong Stock Pulled
	<u> </u>	Cuffs					Contamination	_	Mainte		<u> </u>	Part Moved			
		Heat Treat			1		Countersink		Mislabe			Positioned V	F		
	_	Inspection	•	Tube			Cut Too Short		Misread	d	Ĺ	Power Loss/	Surge		Other
	_	Ripples in I			_		Drill Holes		Offset						
		Torque Wa		xtrusio	י ב		Drawing			Calibration					
		Turning Se	•		Į.		Finish		1	Sequence					
		Wave/Twis	st in Tub	e			Folio		Outside	Dimensions					

August-09-12 10:12:04 AM

Item ID:

D350-591-311

09/08/2012

Accept

\*N900040100\*

Setup Start

**Revision ID:** 

Item Name: Start Date:

Heli-Access-Step, Long LH

\*10\*

**Cust Item ID:** 

**Customer:** 

**Required Date:** 23/08/2012

**Start Oty: 10.00** Reg'd Oty: 10.00

\*10\*

Reference:

Approvals:

**Process Plan:** 

QC:

Date: Date: **Tooling:** 

SPC (Y/N):

Date:

Date:

Run

Sequence ID/ **Work Center ID**  Operation Description

QC10- Inspect visual per QSI004- ground welds

Set Up/ **Run Hours**  Tool ID

Tool # Plan Code Accept Qty

Reject Reject Qty Number

Stop

Insp. Stamp

\*190\*

190

QC

Memo

Memo

Quality Control

200

\*200\* QC

Quality Control

QC5- Inspect part completeness to step on W/O

210

Chemical Conversion Coat per QSI005 4.1

0.00

\*210\*

HandFinish

Memo

0.00

Hand Finishing

											DQA:	Date	e:
NCR:	Yes	/ No				WORK ORDER NON-	CO	NFORI	MANCE / UP	DATE			,
						<u> </u>					QA Closed:	Date	2:
Work Ord	er.					DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
						Rework			Skid-tube	Crosstube	Dro	Water Jet	Engineering Quality
Part	NO.	·			<del></del>	Scrap	$\dashv$	1	Machining	Small Fab	4	d. Eng. Coor.	Other
NCR	No.					Use-as-is Work Order Update	1		noforming	Finishing Composite	Rec/Sto	re/Packaging Supplier	Other
Root					Descri	tion of work order update	T	Initial	Act	tion	Sign &		
Cause		Date	Step	Qty	C	or Non-conformance	Cł	nief Eng	Desci	ription	Date	Verification	QC Inspector
Doc/Data													
Equip/Tooling													
Operator												ļ	
Material				*				<i>,</i> • •					
Setup													
Other						ý.							
Process	-												
Supplier													
Training													
Unapproved													
							AUI	T CATE	GORY			_	
Landi	ng (	Gear				General		-					
Bending								Grain			Ovalized	. [	Pressure/Forced
	Centre Not Concentric to O/S BOM/Ro					BOM/Route		Hardwa	re		Over/Under	tolerance	Temperature/Cure
Cracks						Broken/Damaged		Inspecti	on Incomplete		Part Incorre	ct	Weld
Crushed/Crimped						Burrs		Instruct	ions Incomplete/I	Unclear	Part Lost/M	issing	Wrong Stock Pulled
	Cuffs					Contamination Maintenance Part Moved							
		Heat Trea	t			Countersink		Mislabe	led		Positioned \	Vrong	
					Cut Too Short	Misread			Power Loss/	Surge	Other		

Offset

Out of Calibration
Out of Sequence

Outside Dimensions

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Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Torque Waves in Extrusion

Drill Holes

Drawing

Finish

Item ID: Revision ID:	D350-591-3			Accept	*N9000	14010	<b>10</b> *	Setup		*NS1*	
Item Name: Start Date: Required Date: Reference:	Heli-Access-S 09/08/2012 23/08/2012	Start Qty: 10.00 Req'd Qty: 10.00	*10* *10*		Cust Item ID: Customer:	:			Stop	*NS2*	•
Approvals:		in:	Date:	Tooling: SPC (Y/N):	Date Date				Start Stop	*NR1* *NR2*	t t
Sequence ID/ Work Center II 220 * 770* Powdercoat Powder Coating  230 * 730* HandFinish Hand Finishing	, B4	Operation Description White Gloss(Ref.4.3.5.1) p  Memo START TIME OVEN TEMP FINISH TIME Wing Walk as per dwg QS  Memo	:	Set Up/ Run Hours 0.00 0.00 0.00 2.50@c)	Tool ID	Tool # Pla Coo	de Qty	Qty	1	Reject Insp. Number Stamp 12/0	2
240 * <b>74</b> * QC Quality Control		QC3- Inspect Part Finish  Memo		0.00			10	LA	þ	Bl 12	18-01

										DQA:	Date:	· · · · · · · · · · · · · · · · · · ·
NCR:	Yes / No				WORK ORDER NON-O	100	NFOR	MANCE / UP	DATE		-	,
										QA Closed:	Date:	
Work Ord	er:				DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
WOIK OIG	e				Rework			Skid-tube	Crosstube	]	Water Jet	Engineering
Part f	No				Scrap		1	Machining	Small Fab	Pro	d. Eng. Coor.	Quality
					Use-as-is		Thern	noforming	Finishing	Rec/Sto	re/Packaging	Other
NCR 1	No				Work Order Update	J		Large Fab	Composite	_	Supplier	
		1	1			_			•	T 6: 0		
Root					ption of work order update	1	nitial		ion	Sign &	V 161 - 111 -	
Cause	Date	Step	Qty	(	or Non-conformance	Ch	ief Eng	Descr	ription	Date	Verification	QC Inspector
Doc/Data												
Equip/Tooling			i									
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Material												
Setup				}								
Other		1										
Process												
Supplier												
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Unapproved			<u> </u>			<u> </u>						
				· · · · · · · · · · · · · · · · · · ·		AUL	T CATE	GORY				
Landi	ng Gear				General				<del></del>	٦		Ī
	Bending			<u> </u>	Bend	-	Grain			Ovalized		Pressure/Forced
	Centre Not Concentric to O/S				BOM/Route	Ш	Hardwa	re		Over/Under		Temperature/Cure
	Cracks				Broken/Damaged	_		on Incomplete		Part Incorre		Weld
	Crushed/Crimped.				Burrs		Instruct	ions Incomplete/l	Jnclear	Part Lost/Mi	ssing	Wrong Stock Pulled
	Cuffs				Contamination	Ш	Mainte	nance		Part Moved		E
	Heat Tre	at			Countersink		Mislabe	led		Positioned V	Vrong	

Misread

Out of Calibration

Out of Sequence

Outside Dimensions

Offset

Other

Power Loss/Surge

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Inspection Strip in Tube

Torque Waves in Extrusion

Cut Too Short

Drill Holes

Drawing

Finish

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#### Work Order ID 88884 \*88884\*

August-09-12 10:12:04 AM

Item ID:

D350-591-311

Accept

\*N900040100\*

Setup Start

**Revision ID:** 

Item Name: Heli-Access-Step, Long LH

**Cust Item ID:** 

**Start Date: Required Date: 23/08/2012** 

09/08/2012

**Start Oty: 10.00** Reg'd Qty: 10.00 \*10\* \*10\*

**Customer:** 

Reference:

Process Plan: **Approvals:** 

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/ Work Center ID Operation **Description** 

Set Up/ **Run Hours**  Tool ID

Tool # Plan Code

Reject Accept Qty

Reject

Insp. Number Stamp

\*250\*

Packaging Packaging

250

Pick Kit

Memo

Memo

0.00

0.00

Otv

260

\*260\*

QC

QC4-100% Inspect kits for completeness

0.00

0.00

0.00

Quality Control

270

\*270\* Packaging

Packaging

Packaging

Identify and pack for shipping as per PPPD350-591-311

Location:

Memo

										DQA:	Date	:
NCR:	es / No				WORK ORDER NON-	CON	IFOR	MANCE / UF	PDATE	QA Closed:	Date	
Work Orde	or:				DISPOSITION				AGAINST D	EPARTMENT	<del></del>	•
Part N	lo				Rework Scrap Use-as-is Work Order Update			Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite		Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root				Descri	ption of work order update	lı	nitial	Ad	ction	Sign &		
Cause	Date	Step	Qty	C	or Non-conformance	Chi	ef Eng	Desc	cription	Date	Verification	QC Inspector
Doc/Data												
Equip/Tooling												
Operator						1						
Material [												
Setup										·		
Other												
Process												
Supplier												
Training												
Unapproved						1						
-					F	AUL	CATE	GORY				
Landir	ng Gear				General							
	Bending				Bend		Grain			Ovalized		Pressure/Forced
	Centre No	ot Concer	ntric to C	)/S	BOM/Route		Hardwa	re		Over/Under	tolerance	Temperature/Cure
Cracks					Broken/Damaged	П	Inspecti	on Incomplete		Part Incorre	ct 🗍	Weld
Crushed/Crimped.					Burrs	П	Instruct	ions Incomplete,	/Unclear	Part Lost/Mi	ssing	Wrong Stock Pulled
Cuffs					Contamination	П	Mainte	nance	Γ	Part Moved	<u> </u>	_
ľ	Heat Trea	it			Countersink		Mislabe	led		Positioned V	Vrong	
ŀ	Inspection	n Strip in	Tube		Cut Too Short	П	Misread	ł		Power Loss/	Surge	Other
ļ	Ripples in	-			Drill Holes	П	Offset		_	_	lum.	

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish Folio

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# **Picklist Print**

August-09-12 10:12:12 AM

Work Order ID: 88884

\*88884\*

D350-591-311

Parent Item Name: Heli-Access-Step, Long LH

\*D350-591-311\*

**Start Date:** 09/08/2012

**Required Date: 23/08/2012** 

**Start Qty: 10.00** 

Required Qty: 10.00

**Comments:** 

Parent Item:

IPP Rev:A04.03.22New issue KJ/RF

IPP Rev:B 07-06-09 Added D3272-1 JLM

IPP C returned to CHG001 for Eurocopter, ref NCR08-082 LL verifed

by:EC

IPP Rev:D fixe route seq in bom DD 10.04.28 verified by:EC

*					Acres								
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3272-1		Manufactured	No			110	Each	0.0000	1	10			
*D3272-1*					B88070	=10			**		1/2 12	108	09
				Location		Loc Q	<u>ty</u>	Loc Code		_			
				ST			-10			10			
				WA			10						
D3067-1		Manufactured	No			110	Each	111.0000	1	10	N		
*D3067-1*									**		1212	.08.0	29
				Location		Loc Q	ty	Loc Code					

Location	Loc Qty	Loc Code	
WA	107		
78608	4		
83855	1		
84534	42		
87832	60		
WA016	4		
67582	2		
68214	1		
79607	1		

NCR:	NCR: Yes / No WORK ORDER NON-CONFORMANCE / UPDATE ,												
											QA Closed:	Date:	
Work Ord	er.					DISPOSITION				AGAINST DE	PARTMENT,	/PROCESS	
Part I	-					Rework Scrap			Skid-tube Machining	Crosstube Small Fab	1	Water Jet d. Eng. Coor	Engineering Quality
NCR i	۷o. <u>-</u>					Use-as-is Work Order Update	}		noforming Large Fab	Finishing Composite	Rec/Stor	e/Packaging Supplier	Other
Root					Descri	otion of work order update	i i	nitial	Act	ion	Sign &		
Cause		Date	Step	Qty	c	or Non-conformance	Ch	ief Eng	Descr	ription	Date	Verification	QC Inspector
Doc/Data													
Equip/Tooling							ł						
Operator									-				
Material													
Setup													
Other				,									
Process													
Supplier													
Training													
Unapproved													
							FAUL	T CATE	GORY				
Landi	ng G	ear			_	General					•	<del></del>	
		Bending				Bend		Grain			Ovalized		Pressure/Forced
		Centre No	t Concer	tric to (	D/S	BOM/Route		Hardwa	re		Over/Under		Temperature/Cure
		Cracks				Broken/Damaged		Inspecti	on Incomplete		Part Incorred	ct L	Weld
		Crushed/0	Crimped.			Burrs		Instruct	ions Incomplete/U	Jnclear	Part Lost/Mi	ssing	Wrong Stock Pulled
	Cuffs					Contamination		Mainte	nance		Part Moved		
		Heat Trea	t			Countersink		Mislabe	led		Positioned V	Vrong	_
		Inspection	Strip in	Tube		Cut Too Short		Misread	l		Power Loss/	Surge	Other
	П	Ripples in	Bend			Drill Holes		Offset					

Out of Calibration

Out of Sequence

Outside Dimensions

DQA:

Date:

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

August-09-12 10:12:12 AM

Work Order ID: 88884 \*88884\* Parent Item: D350-591-311 \*D350-591-311\* Parent Item Name: Heli-Access-Step, Long LH **Start Date:** 09/08/2012 **Required Date: 23/08/2012** Required Qty: 10.00 **Start Qty: 10.00** D3219-1 Manufactured No 110 Each 190.0000 A12.08.09 \*D3219-1\* \*\* Location Loc Oty Loc Code WA 172 82221 55 83852 117 WA016 18 73410 12 6 77674 D3066-1 180 Each 115.0000 Manufactured No 20 Ae 12.08.16 **\*** \*D3066-1\* \*\* Location Loc Qty Loc Code WA 115 68 85449 47 86964 MS20600-AD4W4 180 2,546.000 Purchased No Each M121652 (X160) Ac 12.08.16

\* \*MS20600-AD4W4\* Rivets

> Location Loc Qty Loc Code 321 498 121652 498 ST321 2048 121011 9 121340 39

> > 2000

\*\*

121444

NCR:	NCR: Yes / No WORK ORDER NON-CONFORMANCE / UPDATE												
										<u> </u>	QA Closed:	Date	:
Work Ord	er.					DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
WOIR OIG	-					Rework	7 l		Skid-tube	Crosstube	7	Water Jet	Engineering
Part f	Nο					Scrap	1		Machining	Small Fab	-1	d. Eng. Coor.	Quality
	_				<del></del>	Use-as-is	1 1		noforming	Finishing	╡	re/Packaging	Other
NCR I	No.					Work Order Update			Large Fab	Composite	]	Supplier	
Root	1				Descri	ption of work order update		nitial	Act	ion	Sign &		
Cause	ŀ	Date	Step	Qty	(	or Non-conformance	Ch	ief Eng	Descr	ription	Date	Verification	QC Inspector
Doc/Data													
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Process	Ш						1						
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							AUL	T CATE	GORY				
Landi					_	General		۱		<u></u>	7	_	¬_
	-	Bending	-			Bend	$\vdash$	Grain			Ovalized	<u> </u>	Pressure/Forced
	Centre Not Concentric to O/S BOM/Route				$\vdash$	Hardwa		<u> </u>	Over/Under		Temperature/Cure		
	<b>├</b>				Broken/Damaged	$\vdash$		on Incomplete		Part Incorred	<del> </del>	Weld	
	-	Crushed/C	Crimped.		-	Burrs			ions Incomplete/l	Jnclear	Part Lost/Mi	ssing	Wrong Stock Pulled
	-	Cuffs			<u> </u>	Contamination	-	Mainte		<u> </u>	Part Moved		
	⊢	Heat Trea			<u> </u>	Countersink	$\vdash$	Mislabe			Positioned V		٦٠٠٠
	$\vdash$	Inspection	•	Tube		Cut Too Short					Other		
	i is	Rinnles in	Rend		ı	IDrill Holes	1 1	Offset					

Out of Calibration

Out of Sequence

Outside Dimensions

DQA:

Date:

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

# **Pieklist Print**

August-09-12 10:12:12 AM

Work Order ID: 88884

\*88884\*

Parent Item:

D350-591-311

\*D350-591-311\*

Parent Item Name: Heli-Access-Step, Long LH

**Start Date:** 09/08/2012

**Required Date: 23/08/2012** 

**Start Qty: 10.00** 

Required Qty: 10.00

D3065-041

No Manufactured

180

Each 61.0000

\*\*

10

Le 12.08.16

\*D3065-041\*

Step Leg Assembly Hi

<b>Location</b>	<u>I</u>	<u>.oc Qty</u>
WA		31
66149		0
79336		1
83870		5
83871		25
WA013		30
	180	Eac

111.0000 ch

Loc Code

D3067-1

Manufactured No

Purchased

\*\*

\*D3067-1\*

End Plate

No		

Location Loc Oty WA 107 78608 83855 84534 42 87832 WA016 67582 68214 79607 250 Each

Loc Code 94.0000

\*\*

Location ST353 122416 Loc Qty 94 Loc Code

										DQA:	Date:			
NCR:	Yes / N	O			WORK ORDER NON-O	CON	NFOR	MANCE / UPI	DATE			,		
										QA Closed:	Date:			
Work Ord	or:				DISPOSITION				AGAINST DE	PARTMENT	PARTMENT/PROCESS			
WOIK OIG	CI.				Rework	7 <b> </b>	Skid-tube Crosstube			1	Water Jet	Engineering		
Part No.					Scrap	1	ı	Machining	Small Fab	Pro	d. Eng. Coor.	Quality		
					Use-as-is		Thern	noforming	Finishing	Rec/Sto	e/Packaging	Other		
NCR No.				Work Order Update	]		Large Fab	Composite	Supplier					
Root				Descri	ption of work order update	l l	nitial	Act	tion	Sign &				
Cause	Date	Step	Qty	C	or Non-conformance	Ch	ief Eng	Descr	ription	Date	Verification	QC Inspector		
Doc/Data														
Equip/Tooling														
Operator		1 1												
Material														
Setup														
Other														
Process														
Supplier														
Training														
Unapproved												,		
					F	AUL	T CATE	GORY						
Landi	ng Gear				General					-		<b>-</b>		
	Bendin	g		<u></u>	Bend	Ш	Grain			Ovalized		Pressure/Forced		
	Centre	Not Conce	ntric to	o/s	BOM/Route		Hardwa	re		Over/Under	tolerance	Temperature/Cure		
	Cracks				Broken/Damaged		Inspecti	on Incomplete		Part Incorred	it	Weld		
	Crushe	d/Crimped			Burrs		Instruct	ions Incomplete/l	Jnclear	Part Lost/Mi	ssing	Wrong Stock Pulled		
	Cuffs				Contamination		Mainte	nance		Part Moved		*,* *, *, *, *, *, *, *, *, *, *, *, *,		
	Heat T	eat			Countersink		Mislabe	led		Positioned V	Vrong	_		
	Inspect	ion Strip in	Tube		Cut Too Short		Misread			Power Loss/	Surge	Other		
	Ripples in Bend				Drill Holes		Offset			=				

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

August-09-12 10:12:13 AM

Work Order ID: 88884

Parent Item:

D3235-1

D350-591-311

Parent Item Name: Heli-Access-Step, Long LH

\*88884\*

\*D350-591-311\*

Start Date: 09/08/2012

**Start Oty:** 10.00

Required Date: 23/08/2012

Required Qty: 10.00

Manufactured No 250

Each

86.0000

Loc Code

Manufactured No Location Loc Qty ST481 83853 250

86 86 Each 63.0000

Location Loc Oty Loc Code ST471 23 23

ST481 40 83858 40 250 Each

29.0000 160

\*\*

MIZZUY

AN960JD416 NAS1149D0463J Purchased

NAS1149D0563J Purchased

No

No

Location Loc Qty Loc Code ST351 29 116289 8 21 119097 250 Each

28.0000

M121255 12/8/2350

Loc Oty Location Loc Code ST338 28 1069059 8 2612 12 2617

NCR:	CR: Yes / No WORK ORDER NON-CONFORMANCE / UPDATE												
								-		QA Closed:	Date:	,	
Work Ord	er:				DISPOSITION				AGAINST DE	PARTMENT/PROCESS			
Part No					Rework Scrap Use-as-is Work Order Update	Machining Small Fabilities Thermoforming Finishing			Small Fab Finishing	-1	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other	
Root				Descri	ption of work order update		nitial	Act	ion	Sign &			
Cause	Da	e Step	Qty		or Non-conformance	Ch	ief Eng	Descr	ription	Date	Verification	QC Inspector	
Doc/Data													
Equip/Tooling	Ш												
Operator													
Material	Ш												
Setup	Ш												
Other													
Process													
Supplier	<u> </u>				Company of the second	-							
Training													
Unapproved	<u> </u>						T CATE	<u> </u>				(	
1 41		· · · · · · · · · · · · · · · · · · ·				AUL	T CATE	GORY					
Lanoi	ng Gear Bend	<b></b>			General Bend		Grain			Ovalized	Γ-	Pressure/Forced	
		rig e Not Conci	entric to C	1/5	BOM/Route	_	Hardwa	uro.	<u> </u>	Over/Under	tolerance	Temperature/Cure	
	Crack		entire to c	″³  -	Broken/Damaged	$\vdash$		ion Incomplete	<u> </u>	Part Incorred	<del></del>	Weld	
	<del></del>	, ed/Crimped	4	٠ -	Burrs	-		ions Incomplete/L	Inclear	Part Lost/Mi	<del> </del>	Wrong Stock Pulled	
	Cuffs	ca, cimpe			Contamination	-	Mainte		- Incical	Part Moved	531116	J W Torng Stock T unicu	
	Heat	reat			Countersink	$\vdash$	Mislabe			Positioned V	Vrong		
		ction Strip i	n Tube		Cut Too Short	$\vdash$	Misread			Power Loss/		Other	
	<b>—</b>	s in Bend			Drill Holes	$\vdash$	Offset		<b>L</b>	·	~ <u>L</u> _		
	⊢ ``	e Waves in	Extrusion		Drawing	П	Out of (	Calibration					
	Turning Sequence			Finish		Out of Sequence							

Outside Dimensions

DQA:

Date:

Wave/Twist in Tube

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

### **Picklist Print**

August-09-12 10:12:13 AM

Work Order ID: 88884

\*88884\*

Parent Item:

D350-591-311

\*D350-591-311\*

Parent Item Name: Heli-Access-Step, Long LH

Start Date: 09/08/2012 **Start Qty: 10.00** 

**Required Date: 23/08/2012** 

Required Qty: 10.00





Purchased

Manufactured

Manufactured

No

No

No

250

106.0000 Each



Loc Code Loc Qty

ST340

Location ST338

122141

100 100 250 Each

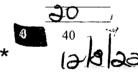
43.0000

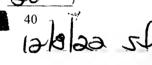


Location	Loc Qty					
ST012		43				
76130		2				
84646		41				
	250	Each				

184.0000

Loc Code







Location Loc Qty Loc Code ST472 184 184 84134

											DQA:	Date:	•
NCR:	Yes /	No				WORK ORDER NON-	CON	IFORI	MANCE / UP	DATE			,
											QA Closed:	Date:	
Work Order:						DISPOSITION	SITION AGAINST DEP			PARTMENT	/PROCESS		
Part No.						Rework Scrap Use-as-is	Scrap Machining Small Fab			Water Jet Prod. Eng. Coor. Rec/Store/Packaging		Engineering Quality Other	
NCR No.				Work Order Update				]	Supplier				
Root					Descri	ption of work order update	lr	nitial	Ac	tion	Sign &		
Cause	D	ate	Step	Qty	<u>)</u>	or Non-conformance	Chi	ef Eng	Desc	ription	Date	Verification	QC Inspector
Doc/Data													
Equip/Tooling				•									
Operator	Ш												
Material	Ш												
Setup	Ш												
Other	Ш	l											
Process	Ш												
Supplier												i	· ·.
Training	Ш												
Unapproved													
	<u> </u>			*		F	AULT	CATE	GORY				
Landi	ng Gear				<del></del>	General	_						
	Ben	ding				Bend	Grain			Ovalized		Pressure/Forced	
	Cent	tre Not	t Concen	tric to	o/s	BOM/Route	Hardware Over/Unde			Over/Under	tolerance	Temperature/Cure	
	Cracks					Broken/Damaged	Inspection Incomplete Pa			Part Incorred	rt I	Weld	

Instructions Incomplete/Unclear

Maintenance

Out of Calibration

Out of Sequence

Outside Dimensions

Mislabeled

Misread

Offset

Part Lost/Missing

Positioned Wrong

Power Loss/Surge

Part Moved

Wrong Stock Pulled

Other

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Crushed/Crimped.

Inspection Strip in Tube

Torque Waves in Extrusion

Cuffs

Heat Treat

Burrs

Contamination

Countersink

Cut Too Short

Drill Holes

Drawing

Finish

August-09-12 10:12:13 AM

Work Order ID: 88884

Parent Item:

D350-591-311

Parent Item Name: Heli-Access-Step, Long LH

\*88884\* \*D350-591-311\*

Location

**Start Date:** 09/08/2012

**Required Date: 23/08/2012** 

**Start Qty: 10.00** 

1.2

Required Qty: 10.00

D2856-400

\*D2856-400\*

Manufactured

No

250

202.4425

Loc Code

3,427.000

\*\*

Loc Oty

20

12

Abrasion Strip

'\* cut (2) at 7.20" (D2856-400-720) \*\*\*

Purchased

No

ST403 96.998 96.998 ST409 105.4445 63735 0.6696 68076 0.3149 71164 8.46 86905 96 250

Each

1815

\*\*

Location	Loc Qty	Loc Code
316	831	
122452	831	
ST300	781	
117885	32	
119017	603	
T19075	138	
121444	8	
ST317	1815	

122141

NCR:	R: Yes / No WORK ORDER NON-CONFORMANCE / UPDATE											
										QA Closed:	Date:	· · · · · · · · · · · · · · · · · · ·
Work Orde	~ · ·				DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
Work Orde	er			<del></del>	Rework	Rework Skid-tube Crosstube			Crosstube	1	Water Jet	Engineering
Part N	No.				Scrap	- I		Machining	Small Fab	Pro	d. Eng. Coor.	Quality
				- ··· - ···	Use-as-is	<b></b>		noforming	Finishing	4	re/Packaging	Other
NCR No.			Work Order Update	]		Large Fab	Composite	]	Supplier			
Root					ption of work order update		nitial	Act		Sign &	_	
Cause	Date	Step	Qty		or Non-conformance	Chi	ief Eng	Descr	ription	Date	Verification	QC Inspector
Doc/Data												
Equip/Tooling												
Operator												
Material												
Setup												
Other												
Process				~								:: .
Supplier												:-
Training					,	-						
Unapproved		<u> </u>				<u> </u>				<u></u>		
						AUL	CATE	GORY				
Landi	ng Gear			_	General				r	7	ļ	<b>.</b>
	Bending			<u> </u>	Bend	$\vdash$	Grain			Ovalized	<u> </u>	Pressure/Forced
	Centre No	ot Concer	ntric to (	D/S	BOM/Route		Hardwa		<u> </u>	Over/Under	_	Temperature/Cure
	Cracks				Broken/Damaged	-	•	on Incomplete	<u> </u>	Part Incorred	<u> </u>	Weld
	Crushed/	Crimped.		<u> </u>	Burrs			ions Incomplete/U	Jnclear	Part Lost/Mi	ssing	Wrong Stock Pulled
	Cuffs				Contamination	-	Mainte		<u> </u>	Part Moved		
	Heat Trea	it			Countersink		Mislabe	led		Positioned V		7
	Inspection	n Strip in	Tube	<u> </u>	Cut Too Short	$\vdash$	Misread	!	<u></u>	Power Loss/	Surge	Other
	Ripples in Bend				Drill Holes	1 1	Offset					

Out of Calibration

Out of Sequence

Outside Dimensions

DQA:

Date:

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

# **Picklist Print**

August-09-12 10:12:13 AM

Work Order ID: 88884

Parent Item:

D350-591-311

Parent Item Name: Heli-Access-Step. Long LH

\*88884\* \*D350-591-311\*

**Start Date:** 09/08/2012

**Required Date: 23/08/2012** 

Required Qty: 10.00

Purchased	

250

Each

1,135.000

**Start Qty: 10.00** 

<b>Location</b>	Loc C	<u>Oty</u>	Loc Code
ST356		500	
122416		500	
ST357		635	
120187		19	
120422		2	
120770		12	
121652		588	
122063		14	
<del>,</del> _	250	Each	1 724 000

Purchased No

Location	<u>n</u>	Loc Qty	Loc Code	
300		500		
	121652	500		
314		1000		
	122452	1000		
ST300		224		
	108827	4		The state of the s
	116105	1		
	116548	43		
	119109	164		20
	2937	12		

NCR:	CR: Yes / No WORK ORDER NON-CONFORMANCE / UPDATE											
								•	QA Closed:	Date:	•	
Work Orde	er:				DISPOSITION			AGAINST (	DEPARTMENT	/PROCESS		
Part No.					Rework Scrap Use-as-is	Scrap Machining Small Fab				Water Jet d. Eng. Coor. re/Packaging	Engineering Quality Other	
NCR No.				Work Order Update	]   "		Large Fab Composite		Supplier			
Root				Descri	ption of work order update	Initia	al	Action	Sign &			
Cause	Date	Step	Qty		or Non-conformance	Chief E	Eng	Description	Date	Verification	QC Inspector	
Doc/Data												
Equip/Tooling												
Operator						1						
Material								1				
Setup												
Other								i				
Process									İ			
Supplier	_										,	
Training												
Unapproved												
	<u> </u>				<del></del>	AULT CA	ATEC	SORY				
Landir	ng Gear			<del></del>	General			F		_	1	
	Bending				Bend	Gra		_	Ovalized		Pressure/Forced	
	Centre No	ot Concer	ntric to O	/S	BOM/Route	$\vdash$	dwai	<u> </u>	Over/Under	<u> </u>	Temperature/Cure	
ļ	Cracks				Broken/Damaged			on Incomplete	Part Incorre	<del>                                     </del>	Weld	
	Crushed/	Crimped.			Burrs	<del></del>		ons Incomplete/Unclear	Part Lost/M	ssing	Wrong Stock Pulled	
]	Cuffs				Contamination			nance	Part Moved			
1	Heat Trea			<u> </u>	Countersink	-	label	}-	Positioned V		I	
ļ	Inspection	n Strip in	Tube		Cut Too Short	<b>⊢</b> ⊸l	read	Ĺ	Power Loss/	Surge	Other	
Į	Ripples in	Bend			Drill Holes	Offs	et					
- 1	Torque Waves in Extrusion				Drawing	Out	of C	alibration				

Out of Sequence

Outside Dimensions

DQA:

Date:

Turning Sequence

Wave/Twist in Tube

Finish

August-09-12 10:12:14 AM

Work Order ID: 88884

Parent Item:

D350-591-311

Parent Item Name: Heli-Access-Step, Long LH

\*88884\*

\*D350-591-311\*

Start Date: 09/08/2012

**Required Date: 23/08/2012** 

Required Qty: 10.00

Purchased

No

250

Each

**Start Qty: 10.00** 

<u>Location</u>	Loc Q	<u>Loc (</u>	Code
314	50	00	
122452	50	00	<b>2</b> 0
ST300	5	80	
104248		1	
116823		4	
119075	1	16	
121011	1	93	
121444	2	66	
	250	Each 0.00	$00 \qquad \boxed{4} \qquad 40$

NAS1149D0363J Purchased

No

\*\* M121243 /2/8/27 50

NCR:	Yes / No				WORK ORDER NON-	CO	NFORM	MANCE / UP	DATE		<del></del>		
										QA Closed:	Date:		
Work Orde	ar.				DISPOSITION		AGAINST DEPARTMENT/PROCESS						
Part N					Rework Scrap Use-as-is		,	Skid-tube Machining	Crosstube Small Fab Finishing		Water Jet d. Eng. Coor. re/Packaging	Engineering Quality Other	
NCR N	No		<u></u>		Work Order Update	1		Large Fab	Composite	- Rec/stol	Supplier	J Other	
Root				Descri	ption of work order update		Initial	Act	tion	Sign &			
Cause	Date	Step	Qty	(	or Non-conformance	Ch	nief Eng	Desci	ription	Date	Verification	QC Inspector	
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved													
onapproved	<b>L</b>					AUL	T CATE	GORY		1,	<u> </u>	·	
Landir	ng Gear				General								
	Bending Centre No	ot Concer	ntric to (	o/s	Bend BOM/Route Broken/Damaged		Grain Hardware Inspection Incomplete			Ovalized Over/Under Part Incorred	<b>}</b>	Pressure/Forced Temperature/Cure Weld	
	Crushed/0	Crimped			Burrs		Instructi	ions Incomplete/l	Jnclear	Part Lost/Mi	ssing	Wrong Stock Pulled	
ľ	Cuffs				Contamination		Mainte	nance		Part Moved	<u> </u>	_	
ľ	Heat Trea	it			Countersink		Mislabe	led	Γ	Positioned V	Vrong	_	
1	Inspection	n Strip in	Tube		Cut Too Short		Misread		Γ	Power Loss/	Surge	Other	
Ī	Ripples in Bend				Drill Holes		Offset		•	<del></del>			

Out of Calibration
Out of Sequence

Outside Dimensions

DQA:

Date:

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G



		1		•
DESIG	P	DRAWN BY	DART AEROSPACE HAWKESBURY, ONTARIO, CANAD	
CHEC	<b>S</b> ED	APPROVED,	DRAWING NO.	REV. B
		<del>                                    </del>	D3272	SHEET 1 OF 3
DATE			TITLE	SCALE
07.0	5.18		STEP ASSEMBLY, HI LONG	NTS
Α		04.03.01	NEW ISSUE	
В		07.05.18	D3272-1 WAS D2622-120	

OT OF ONE OF

QTY	QTY		
-041	-042	PART NUMBER	DESCRIPTION
X		D3272-041	STEP ASSEMBLY, HIGH LONG (LH)
	Х	D3272-042	STEP ASSEMBLY, HIGH LONG (RH)
1	1	D3065-041	LEG ASSEMBLY
2	2	D3066-1	SPACER
2	2	D3067-1	END PLATE
2	2	D3219-1	SUPPORT
1	1	D3272-1	STEP
16	16	MS20600AD4W4	RIVET

B

#### **GENERAL NOTES:**

- 1) D3272-041 SHOWN. FOR D3272-042, INSTALL D3219-1 SUPPORT OPPOSITE SIDE
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005.4.1 POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3 BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED.
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX.

SHOP COPY

RETURN TO

ENGINEERING
UNICONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
12/08/09/09

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NCR: Yes / No	WORK ORDER NON-CONFO	RMANCE / UPDATE
Work Order	DISPOSITION	AGAINST D

NCR:	Yes	/ No				WORK ORDER NON-	·CO	NFOR	MANCE / UP	DATE					
											QA Closed:	Dat	te:		
Nork Ord	er.					DISPOSITION				AGAINST DE	PARTMENT	PROCESS			
VOIN OIG	Part No.  NCR No.  Ot					Rework	7		Skid-tube	Crosstube	Water Jet			Engineering	
Part I	Vo.					Scrap	1		Machining	Small Fab	Pro	d. Eng. Coor.		Quality	
	Order:  Part No.  NCR No.  Se Date Step Qty  ta Soling Or Step Order  I Seport Step Order  I					Use-as-is	7		noforming	Finishing		e/Packaging		Other	
NCR I	No.					Work Order Update			Large Fab	Composite		Supplier			
Root					Descr	iption of work order update		Initial	Ac	tion	Sign &				
Cause		Date	Step	Qty		or Non-conformance	Cł	nief Eng	Desc	ription	Date	Verification	n	QC Inspector	
oc/Data															
uip/Tooling															
perator															
aterial						•									
tup															
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ocess			[												
pplier															
aining												:			
approved													$\perp$		
						<u> </u>	FAUL	T CATE	GORY						
Landi						General	_	1		Γ	1		$\Box$		
		_			ļ	Bend	<u> </u>	Grain		<u> </u>	Ovalized			Pressure/Forced	
			t Concer	ntric to (	D/S	BOM/Route	$\perp$	Hardwa		<u> </u>	Over/Under		$\vdash$	Temperature/Cure	
					<u></u>	Broken/Damaged		4 .	on Incomplete		Part Incorred			Weld	
	_		Crimped.		L	Burrs		4	ions Incomplete/	Unclear	Part Lost/Mi	ssing	∟'	Wrong Stock Pulled	
		Cuffs				Contamination		Mainte	nance		Part Moved				
		Heat Trea	t		<u> </u>	Countersink	_	Mislabe	led		Positioned V		_		
į		Inspection	Strip in	Tube		Cut Too Short		Misread	I		Power Loss/	Surge		Other	
		Ripples in	Bend			Drill Holes	L	Offset							
		Torque W	aves in E	xtrusior	1 <u> </u>	Drawing		Out of 0	Calibration						
		Turning Se	equence			Finish		Out of S	equence						
		Wave/Twi	ist in Tub	e		Folio		Outside Dimensions							

DQA: \_\_\_\_\_ Date: \_\_\_\_\_

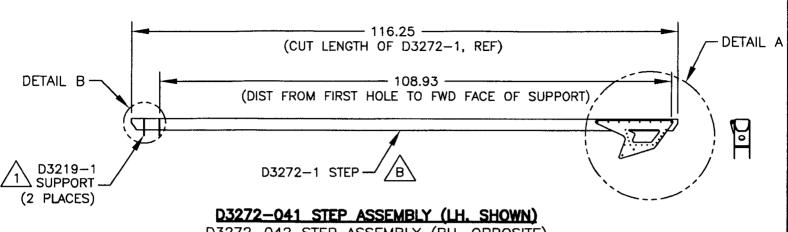
H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

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SHEET

N SCALE 읶

1:20



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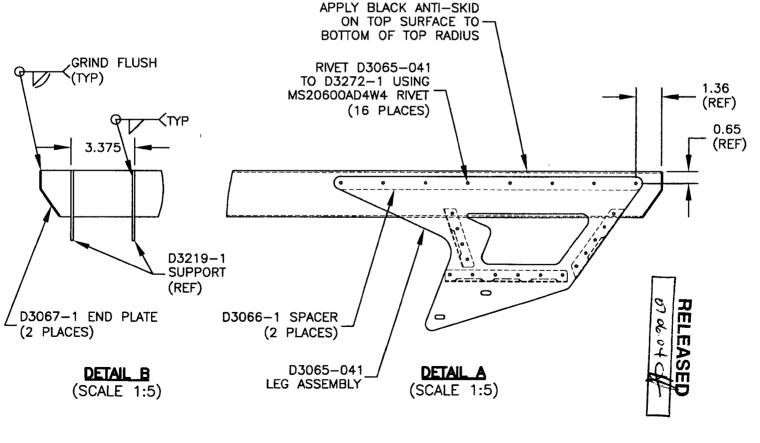
NOT TO BE USED F

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ANY PURPOSE

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D3272-042 STEP ASSEMBLY (RH, OPPOSITE)



										DQA:	Date	:
NCR:	res / No				WORK ORDER NON-O	CONF	ORN	AANCE / UPDAT	ΤE			•
										QA Closed:	Date	<u>.                                      </u>
Work Orde	~r·				DISPOSITION				AGAINST DE	PARTMENT;	/PROCESS	
WOIK Oluk	=				Rework	1 <b>I</b>		Skid-tube C	Crosstube		Water Jet	Engineering
Part N	lo.				Scrap			<b></b>	Small Fab	Pro	d. Eng. Coor.	Quality
			<del></del>		Use-as-is	+		~ <b>}</b>	Finishing		re/Packaging	Other
NCR N	10.				Work Order Update			Large Fab Co	omposite		Supplier	
	7	<del></del>										
Root					ption of work order update	Initi		Action		Sign &		
Cause	Date	Step	Qty	(	or Non-conformance	Chief	Eng	Description	on	Date	Verification	QC Inspector
Doc/Data												
Equip/Tooling												
Operator												
Material												
Setup												
Other												
Process												
Supplier												
Training												
Unapproved												<u> </u>
					FA	AULT C	ATEC	ORY				
Landi	ng Gear				General				,	ı	<b></b>	_
	Bending				Bend	Gra	ain			Ovalized		Pressure/Forced
	Centre No	ot Concer	ntric to	o/s	BOM/Route	Hai	rdwai	re		Over/Under	tolerance	Temperature/Cure
	Cracks				Broken/Damaged	Ins	pection	on Incomplete		Part Incorred	t	Weld
	Crushed/	Crimped			Burrs	Ins	tructi	ons Incomplete/Uncle	ear	Part Lost/Mi	ssing	Wrong Stock Pulled
	Cuffs				Contamination	Ma	ainte	nance		Part Moved		
	Cause Date Step Qty    Data				Countersink	Mis	slabel	ed		Positioned W	/rong	<b></b>
Ī	Inspectio	n Strip in	Tube		Cut Too Short	Mis	sread			Power Loss/:	Surge	Other

Offset

Out of Calibration

Out of Sequence

Outside Dimensions

Drill Holes

Drawing

Finish Folio

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Torque Waves in Extrusion

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

07.05.18

STEP ASSEMBLY,

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LONG

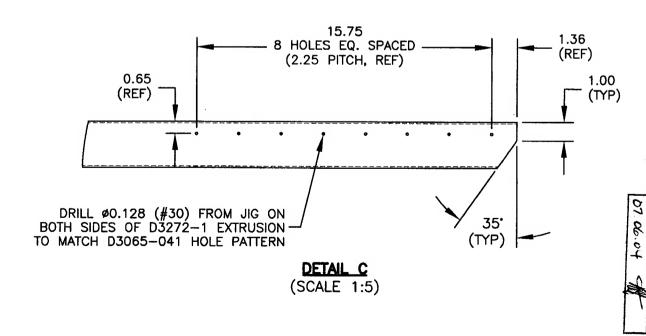
SCALE 1:20

RELEASED

DETAIL C

D3272-1 STEP (MAKE FROM D2622-120 STEP EXTRUSION)

- 116.25



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PURPOSE OR COPIED

D3272 DRAWING NO. AEROSPACE LTD SHEET 3 OF 3

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					*** ***						DQA:	Dat	te:	٤
NCR:	Yes	/ No				WORK ORDER NON-C	O	NFORMANCE / UPDATE						
										QA C	losed:	Dat	te:	
Nork Ord	er:					DISPOSITION			AGAINST	DEPARTI	MENT/	PROCESS		
	•		**			Rework	1		Skid-tube Crosstube			Water Jet		Engineering
Part I	No.					Scrap		_ (	Machining Small Fab		Prod	d. Eng. Coor.		Quality
						Use-as-is Thermoforming			~ <del>  _  </del>	<b></b>	c/Stor	e/Packaging		Other
NCR f	۱o.		-			Work Order Update	j		Large Fab Composite			Supplier		
Root					Descri	ption of work order update	1	nitial	Action	Sig	n &			
Cause		Date	Step	Qty		or Non-conformance	Ch	ief Eng	Description	Da	ate	Verification	<u> </u>	QC Inspector
oc/Data														
quip/Tooling													ļ	
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upplier raining	$\dashv$													
napproved	$\dashv$							4						
паррточес	1					F/	AUL	T CATE	GORY					
Landi	ng G	iear				General				<del>.</del>				
		Bending				Bend		Grain		Ovaliz	ed		F	Pressure/Forced
		Centre No	t Concen	ntric to (	o/s	BOM/Route		Hardwa	re	Over/	Under t	olerance	1	Temperature/Cure
		Cracks				Broken/Damaged		Inspecti	on Incomplete	Part Ir	ncorrec	t [	\	<i>W</i> eld
		Crushed/C	Crimped.			Burrs		Instruct	ions Incomplete/Unclear	Part L	ost/Mis	ssing	\	Wrong Stock Pulled
		Cuffs				Contamination		Mainte	nance	Part N	Noved			
		Heat Treat	t			Countersink		Mislabe	led	Position	oned W	rong		
		Inspection	Strip in	Tube		Cut Too Short		Misread	•	Powe	r Loss/S	urge		Other
		Ripples in	Bend			Drill Holes	Ш	Offset						
	Torque Waves in Extrusion Drawing						Out of Calibration							
		Turning Se	equence			Finish	Out of Sequence							
		Wave/Twist in Tube Folio						Outside	Dimensions					

# REFERENCE ONLY

#### DART AEROSPACE LTD.

D350-591 Page 23 of 23

Qty -211	Qty -212	Qty -213	Qty -214	Qty -215	Qty -216	Qty 311	Qty -312	Part Number	Description
X						111		D350-591-211	Heli-Access-Step™, Long Step – High Skid, LH
<u> </u>	Х		_					D350-591-212	Heli-Access-Step™, Long Step – High Skid, RH
	_^_	х						D350-591-213	Heli-Access-Step™, Short Step - High Skid, LH
			X			<b>†</b>		D350-591-214	Heli-Access-Step™, Short Step – High Skid, RH
				Х		†		D350-591-215	Heli-Access-Step™, Short Step - Low Skid, LH
					X	<del></del>		D350-591-216	Heli-Access-Step™, Short Step – Low Skid, RH
						X		D350-591-311	Heli-Access-Step™, Long Step – High Skid, LH
<del></del>						<del>                                     </del>	х	D350-591-312	Heli-Access-Step™, Long Step – High Skid, RH
ļ <u>-</u>									
1								D3070-041	STEP ASSEMBLY (HIGH-LONG, LH)
	1							D3070-042	STEP ASSEMBLY (HIGH-LONG, RH)
ĺ		1						D3078-041	STEP ASSEMBLY (HIGH-SHORT, LH)
			1					D3078-042	STEP ASSEMBLY (HIGH-SHORT, RH)
				1				D3168-041	STEP ASSEMBLY (LOW-SHORT, LH)
					1			D3168-042	STEP ASSEMBLY (LOW-SHORT, RH)
						1		D3272-041	STEP ASSEMBLY (HIGH-LONG, LH)
							1	D3272-042	STEP ASSEMBLY (HIGH-LONG, RH)
4	4							D2182B035	RUBBER CUSHION
		2	2	2	2			D2230-1	MOUNTING LUG
		2	2	2	2	14	4 -	D2230-3	MOUNTING LUG
8	8					-		D2274	RADIUS BLOCK
						12	2	D2618	BUSHING
4	4	4	4	4	4			D2732-030	CUSHION
2	2	1	1	1	1	L2_	2	D2856-400-720->	ABRASION STRIP
2	2						-	D3064-1	CLAMP
1	1							D3079-041	SUPPORT ASSEMBLY
4	4							D3080-1	CLAMP
				-		2	2	D3235-1	MOUNTING LUG
						1 1	سر 1 رسا	-D3278-041	SUPPORT ASSEMBLY
								410.054	POLT
2	2	2	2	2	2	7-2-	2	AN3-35A /	BOLT
10	10	2	2	2	2			AN4-11A	BOLT
		4	4	4	4	8	8	AN4-13A	BOLT
						7.2-	2 .	AN5-36A	BOLT
4	4	4	4	4	4	14	4	AN960JD10 7	WASHER
20	20	12	12	12	12	z 16	16	السر AN960JD416	WASHER
						14=		AN960JD516	WASHER
2	2	2	2	2	2	12	2 .	-MS21042L3*	NUT
10	10	6	6	6	6	/ 8.	.8	MS21042L4-1_	NUT
						L, 2	_2	-MS21042L5	NUT
						-1	1	*DSI 9410-011	STEP MODIFICATION KIT

<sup>\*</sup>DSI 9410-011 Step Modification Kits are provided with all D350-591-311 and D350-591-312 Steps. This kit is provided as an option for the installer and is therefore **NOT REQUIRED** to complete the installation of the D350-591-311 or D350-591-312 Steps. Refer to Figure 21 for installation of the DSI 9410-011 Kit.

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Revision: G

Date: 08.10.06

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